

Work Order ID 124291

September-11-14 12:01:20 PM

124291

Page 1

Item ID: D3016-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Seat Frame Assembly
Start Date: 9/10/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/10/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MCS Date: 14-09-16 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|----------------|
| D3016 | RevA / DEO A-1 |

100 Weld per dwg A/R 4130 rod Batch: M127925 0.00
Large Fab
100
Large Fab
Large Fab

Memo 0.00
1-Cut all tubes as per Dwg D3016
2-Deburr
3-Assemble tubes, fittings and weld as per Dwg D3016 using welding jig DT8597
4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041
5- Assemble brackets and gusset per dwg and weld

1 ea 14-10-8

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110
QC Memo 0.00
Quality Control

1 **OCT 09 2014** **DAS**
24
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

September-11-14 12:01:20 PM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 9/10/14 **Start Qty:** 1.00 ***1***

Required Date: 9/10/14 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | |
|-----|---|------|
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 |
|-----|---|------|

120

QC

Quality Control

| | |
|-------------|-------------|
| Memo | 0.00 |
|-------------|-------------|

1 OCT 09 2014 DAS
24
9-89

| | | |
|-----|--|------|
| 130 | Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 | 0.00 |
|-----|--|------|

130

Powdercoat

Powder Coating

| | |
|-------------|------|
| Memo | 0.00 |
|-------------|------|

Install paint screws on fitting ends

START TIME: 7:10
OVEN TEMPERATURE: 270°
FINISH TIME: 9:45

1 of 14-10-9

| | | |
|-----|--------------------------|------|
| 140 | QC3- Inspect Part Finish | 0.00 |
|-----|--------------------------|------|

140

QC

Quality Control

| | |
|-------------|-------------|
| Memo | 0.00 |
|-------------|-------------|

1x _____ 14/10/09 DAS
36
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
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| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | |
|--|--|---|
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| | | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge |
| | | <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

Work Order ID 124291

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124291

Page 3

Item ID: D3016-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Seat Frame Assembly

Stop ***NS2***

Start Date: 9/10/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/10/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|-----------------|
| 150 | Identify as per dwg & Stock Location: <u>G.A</u> | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | <u>1X</u> | | | <u>14/10/09</u> |
| Packaging | | | | | | | | | |
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

DAS
36
9-8914/10/14 ME
14-10-10-

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
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| Design | | | | | | | | | |
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| Equip/Tooling | | | | | | | | | |
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| Training | | | | | | | | | |
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| Unapproved | | | | | | | | | |

FAULT CATEGORY

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|--|--|---|--|

Picklist Print

September-11-14 12:01:19 PM

Page 1

Work Order ID: 124291

124291

Parent Item: D3016-041

D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A01.09.19New issueECIPP RevB: as per revB DD verified by:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M4130NT0.750W.049 | | Purchased | No | | | 100 | f | 248.2200 | 4.3 | 5 | | | |
| *M4130NT0 750W 049* | | | | | | | | | | ** | | | |
| 4130 RD Tube .750 x.049W | | | | | | | | | | | | 12/4/07 | |

Location

Loc Qty

Loc Code

MAT022

47.72

m127866

47.72

MAT033

200.5

125313

109.7

m127111

90.8

M4130NT0.500W.049

Purchased

No

100

f

288.6400

4.3

5

M4130NT0 500W 049

4130 RD Tube .500 x.049W

**

Location

Loc Qty

Loc Code

MAT032

288.64

m127111

44.83

m128713

27.81

m129826

216

M4130NT1.000W.120

Purchased

No

100

f

34.5700

1.5

2

M4130NT1 000W 120

4130 RD Tube 1.00 x .120wall

**

Location

Loc Qty

Loc Code

MAT033

34.57

117656

0.07

m126545

34.5

m124293 x 1.25

not in system *

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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| Handling/Pre | | | | | | | | | |
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| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Picklist Print

September-11-14 12:01:19 PM

Page 2

Work Order ID: 124291

124291

Parent Item: D3016-041

D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | | |
|-------------------|--------------|----|-----|------|--------|---|---|--|
| D3016-17 | Manufactured | No | 100 | Each | 6.0000 | 2 | 2 | |
| *D3016-17* | | | | | | | | |
| Gusset | | | | | | | | |

**

EL 14-10-8

Location

Loc Qty

Loc Code

WA002

6

106749

6

2

| | | | | | | | | |
|-------------------|--------------|----|-----|------|---------|---|---|--|
| D3016-13 | Manufactured | No | 100 | Each | 20.0000 | 2 | 2 | |
| *D3016-13* | | | | | | | | |
| Bracket | | | | | | | | |

**

EL 14-10-8

Location

Loc Qty

Loc Code

WA002

20

110111

20

2

| | | | | | | | | |
|-------------------|--------------|----|-----|------|---------|---|---|--|
| D3016-15 | Manufactured | No | 100 | Each | 60.0000 | 2 | 2 | |
| *D3016-15* | | | | | | | | |
| Gusset | | | | | | | | |

**

EL 14-10-8

Location

Loc Qty

Loc Code

WA002

60

112203

40

2

119895

20

| | | | | | | | | |
|------------------|--------------|----|-----|------|---------|---|---|--|
| D3020-1 | Manufactured | No | 100 | Each | 30.0000 | 4 | 4 | |
| *D3020-1* | | | | | | | | |
| Fitting | | | | | | | | |

**

EL 14-10-8

Location

Loc Qty

Loc Code

WA002

30

109928

3

111839

27

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|



| | | | |
|------------------|----------------|---|------------------------|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3016 | REV. A SHEET 1 OF 3 |
| DATE 01.05.18 | | TITLE SEAT FRAME ASSEMBLY SCALE NTS | |
| A | 01.05.18 | NEW ISSUE | |

| QTY | PART NUMBER | DESCRIPTION | MATERIAL |
|-----|-------------|---------------------|--|
| X | D3016-041 | SEAT FRAME ASSEMBLY | N/A |
| 1 | D3016-1 | TUBE | AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049) |
| 2 | D3016-3 | TUBE | AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049) |
| 1 | D3016-5 | TUBE | AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049) |
| 2 | D3016-7 | TUBE | AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049) |
| 1 | D3016-9 | SADDLE | AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120) |
| 1 | D3016-11 | SADDLE | AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120) |
| 1 | D3016-13 | BRACKET | AISI 4130N SHEET, 18 GAUGE (M4130N-S049) |
| 1 | D3016-15 | GUSSET | AISI 4130N SHEET, 18 GAUGE (M4130N-S049) |
| 1 | D3016-17 | GUSSET | AISI 4130N SHEET, 18 GAUGE (M4130N-S049) |
| 2 | D3020-1 | FITTING | N/A |

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 124291MLS

1409-16

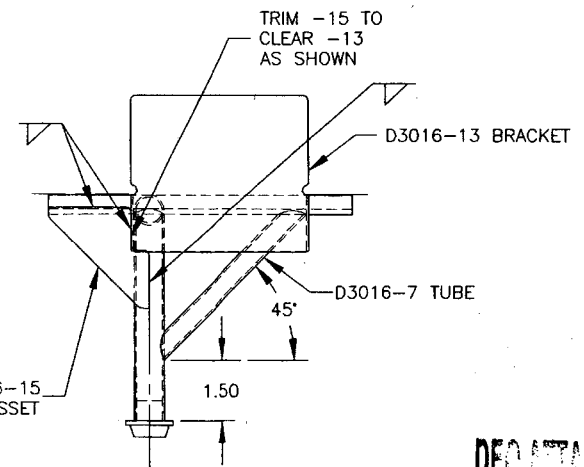
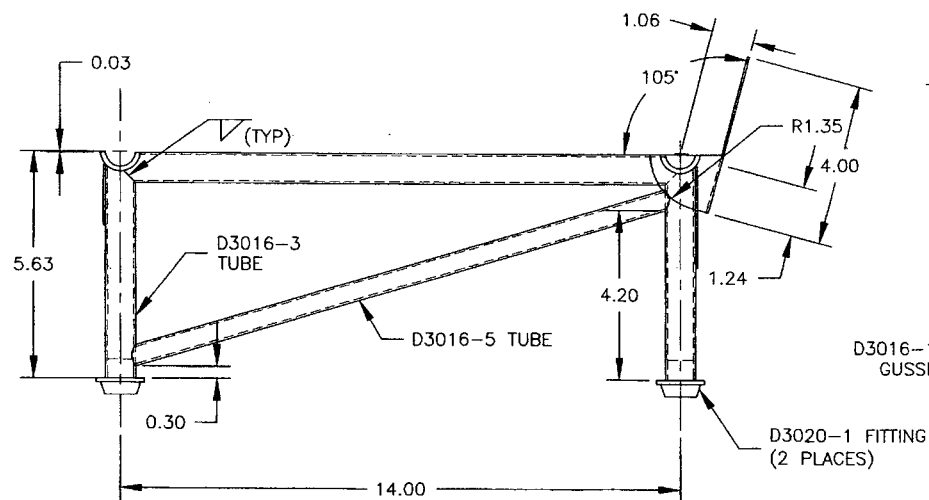
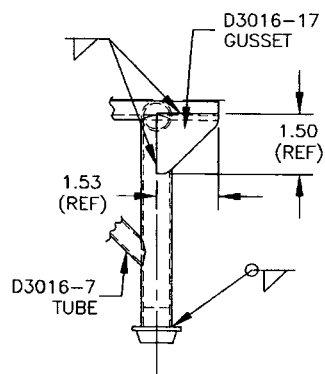
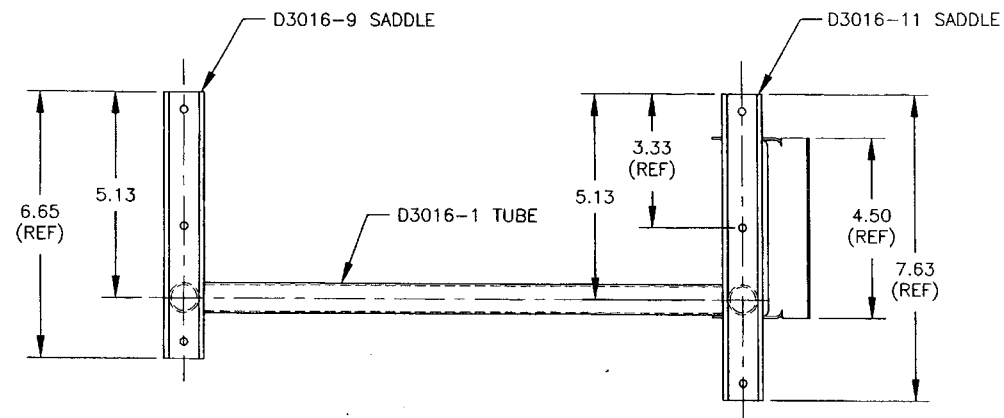
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01.05.30

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D3016-041 SEAT FRAME ASSEMBLY



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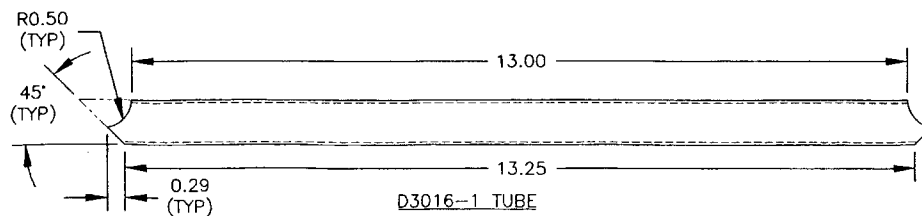
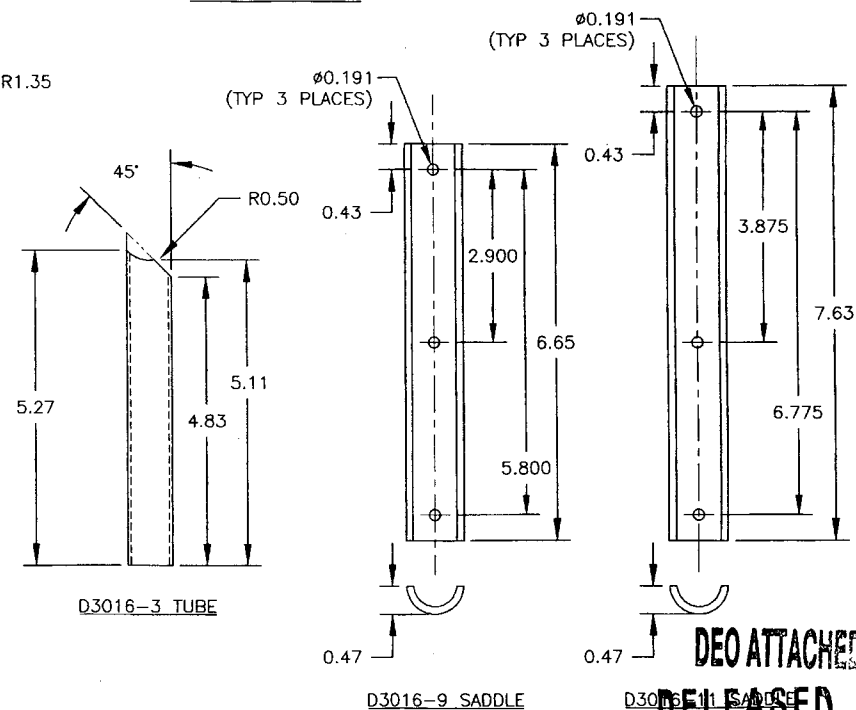
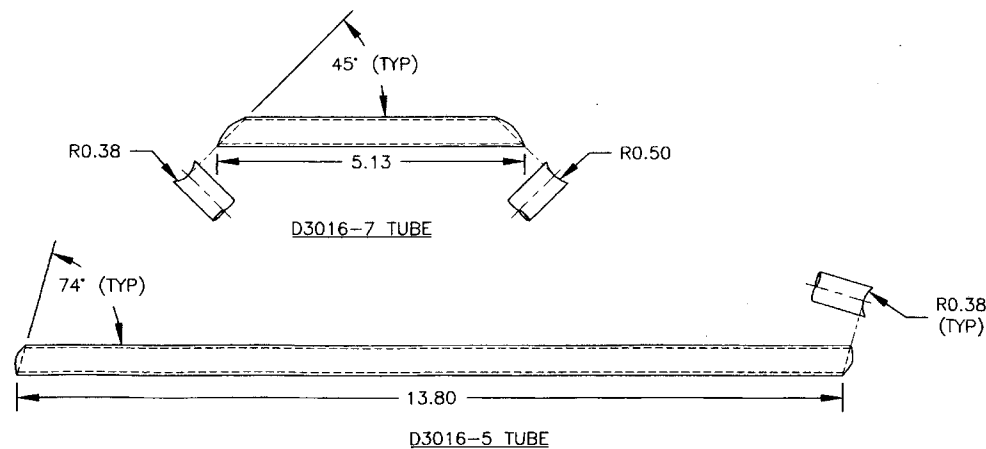
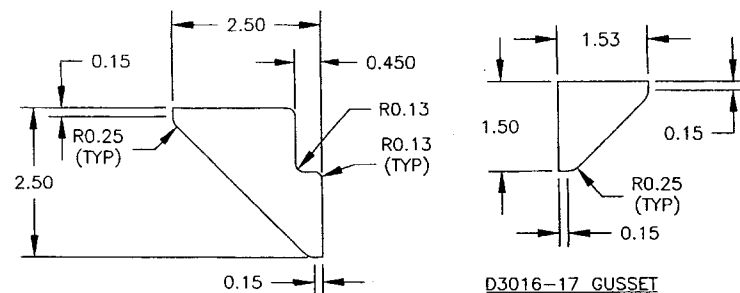
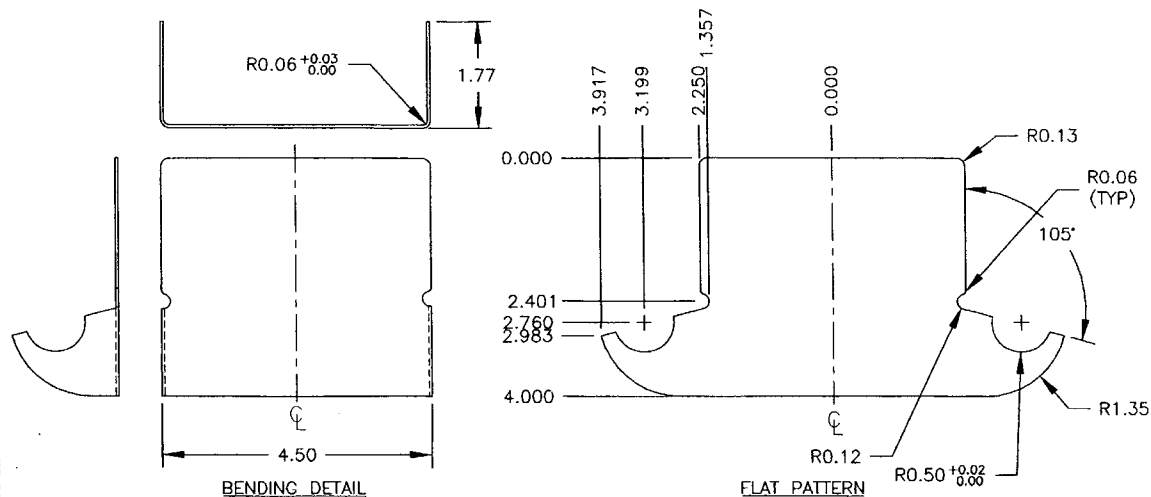
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DESIGN
UP
CHECKED

DATE
01.05.18

DRAWN BY
UP
APPROVED
#

DART DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA
DRAWING NO.
D3016
TITLE
SEAT FRAME ASSEMBLY
REV. A
SHEET 2 OF 3
SCALE
1:3



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| | | | | | |
|---------|----------|----------|---------------------|-------------|--|
| DESIGN | CP | DRAWN BY | CP | DART | DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA |
| CHECKED | # | APPROVED | # | DRAWING NO. | D3016 |
| DATE | 01.05.18 | TITLE | SEAT FRAME ASSEMBLY | REV. A | SHEET 3 OF 3 |
| | | | | SCALE | 1:2 |

DEO ATTACHED
RELEASED
01.05.30 9

| | | | | | | |
|----------------------|------------------------------|---------------------|---|-------------------------|---------------------------|--------------|
| DRAWING NO. D3016 | TITLE SEAT FRAME ASSEMBLY | REV. A | DART AEROSPACE LTD ENGINEERING ORDER | D.E.O. NO. D3016-A-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN 1 | CHECKED UP | MFG. APPR. R | APPROVED WAP | DE APPR. # | | |
| DATE 10.01.29 | DATE 10.01.29 | DATE 10.01.29 | DATE 10.01.29 | DATE 10.01.29 | | |

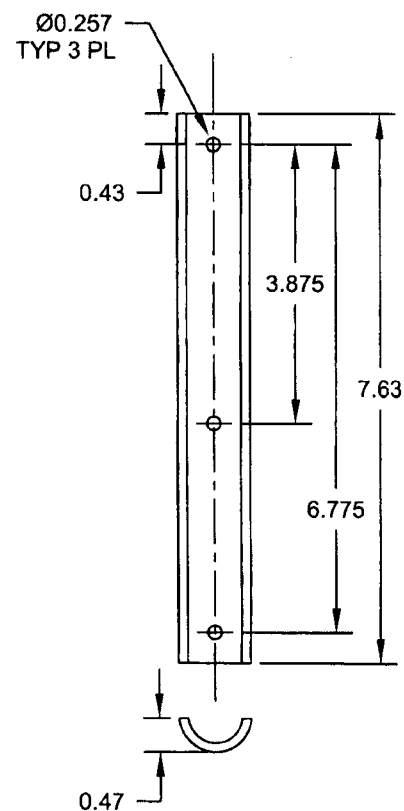
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

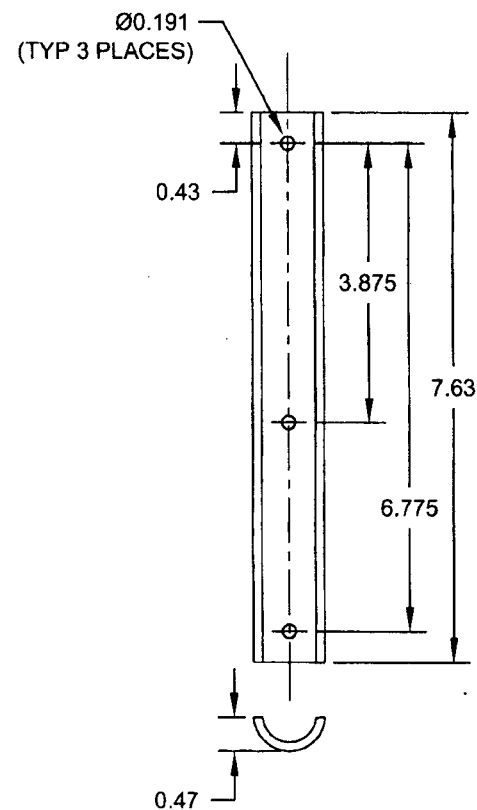
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE